

Work Order ID 56575

Monday, March 01, 2010 3:01:39 PM



Page 1

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/2/2010

Start Qty: 8.00



Cust Item ID:

Required Date: 3/15/2010

Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-3-1

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2888

Rev A2

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut Blanks at 4.200" long
Grain along 4.200"

0.00

0.00

af 10.3.8

9

0

110



HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio D2888
Folio Rev: HA
Dwg Rev: A

2-Deburr

0.00

0.00

af 10.3.8

HA 10/03/09

9

0

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10.3.8
H.A. 10/03/09

9

φ

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

10/03/10

9

φ

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10/03/10

9

φ

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Page 3

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: 7:00am

OVEN TEMPERATURE: 320°

FINISH TIME: 7:30am

0.00

=> MU 10/03/11

(X9)

Ø

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 10-3-11

(9)

Ø

170



Packaging

Packaging

Identify as per dwg & Stock Location: 480

0.00

Memo

0.00

10-3-12

(94) 80

W/O:		WORK ORDER CHANGES					
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Accept

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/10 *[Signature]*
Pl 10-3-14
(9)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, March 01, 2010 3:01:39 PM

Page 1

Work Order ID: 56575

Parent Item: D2888

Parent Item Name: Lug

Comments: IPP C 00.06.22 Removed P/O for powder coat EC

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	33.0343	3.1200			



6061-T6 Bar 2.50 x 3.50



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	33.03425	
102838	13.1	
110936	1.03	
111700	1.365	
113403	17.53925	

del 10.3.8

3.5

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DART AEROSPACE LTD		Work Order: 56575
Description: Lug		Part Number: D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	0.389	✓			
Ø0.88	+/-0.030	Ø0.877	✓			
0.063 x 45°	+/-0.010	0.063 x 45°	✓			
4.06	+/-0.030	4.060	✓			
Ø0.760	+0.005/-0.000	.761	✓			
3.48	+/-0.030	3.483	✓			
2.500	+/-0.010	2.500	✓			
2.75	+/-0.030	2.758	✓			
0.438	+/-0.010	0.439	✓			
0.080 x 45°	+/-0.010	0.077 x 45°	✓			
1.85	+/-0.030	1.850	✓			
1.000	+/-0.010	1.007	✓			
0.425	+/-0.010	0.422	✓			
0.030 x 45°	+/-0.010	0.025 x 45°	✓			
1.875	+/-0.010	1.870	✓			
0.375	+/-0.010	0.369	✓			
R0.25	+/-0.030	R0.250	✓			
1.29	+/-0.030	1.287	✓			
0.414	+/-0.010	0.410	✓			
3.41	+/-0.030	3.394	✓			

Measured by: H.A.	Audited by: SA	Prototype Approval: N/A
Date: 10/03/09	Date: 10/03/10	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	DA

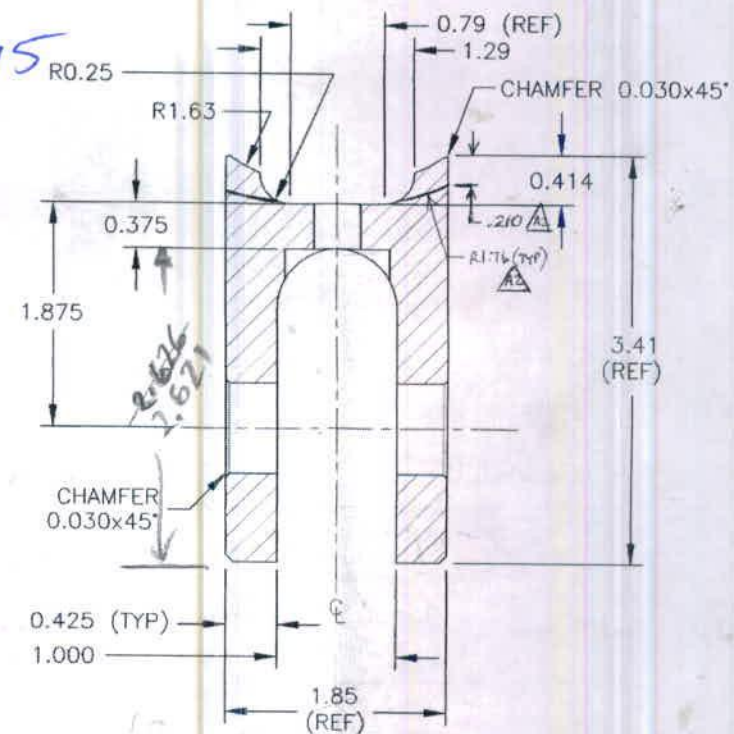
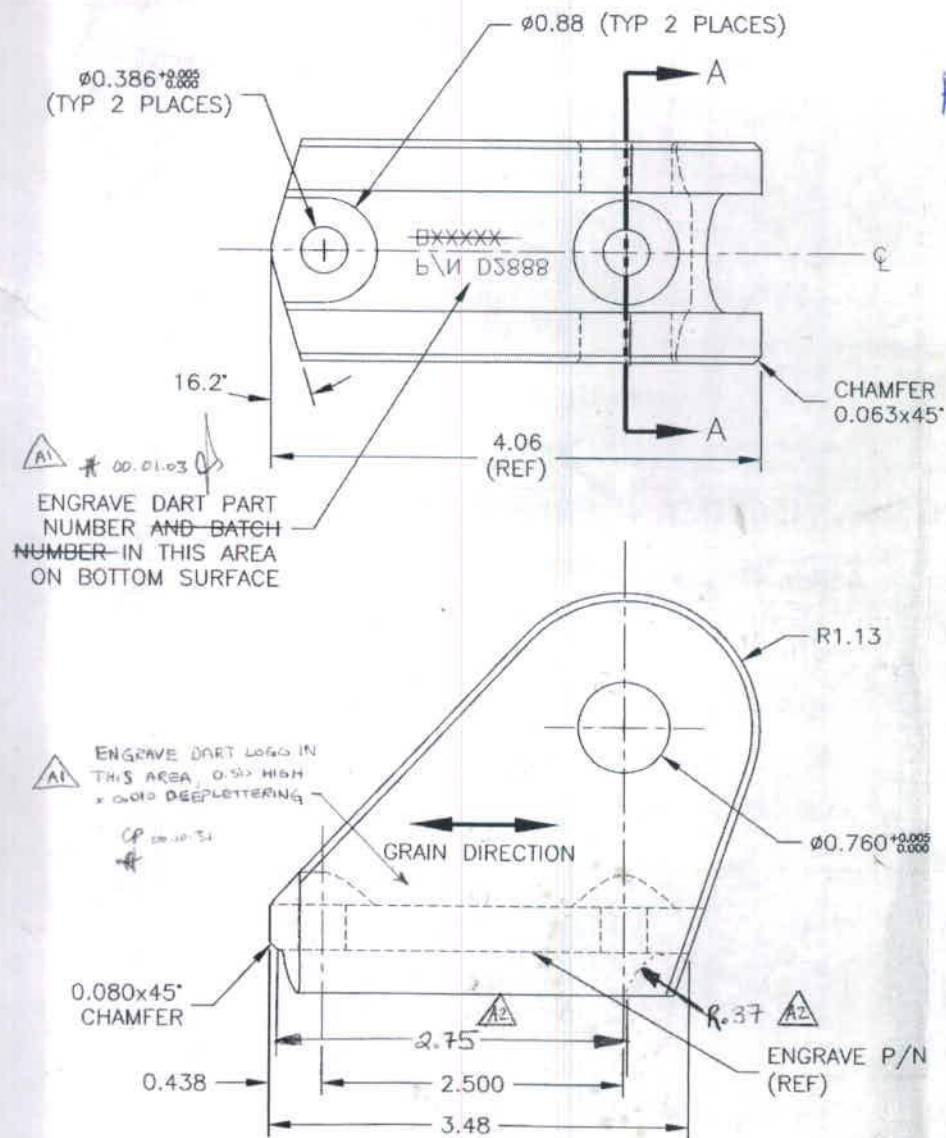
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SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NICK 784	99.06.21	NEW ISSUE	DART	DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA	REV. A
A1	00.10.31	Update Engraving	99.06.21		D2888		SHEET 1 OF 1
					LUG		SCALE 1:1

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